

Work Order ID 144369

April 13, 2016 3:45:03 PM

144369

Page 1

Item ID: D2221 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Base Assembly
 Start Date: 5/13/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/20/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: SK Date **20160410** **4103**ing: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2221	Rev H

100

100

Large Fab

Large Fab

Large Fab

Memo

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
 3- tack weld mesh on basket as per dwg D2221
 A/R ER316 S.S. Rod Batch: 4134102

PLEASE NOTE SEE DWG

IF MAKING -141/-041A CUT BUSHING ON BASE BOTH ENDS, OR -143/-043A CUT BUSHING ON ONE SIDE ONLY OF BASKET BASE AS PER DWG

0.00

2.40

0.00

0.00

DAS

43

9-89 **MAY 30 2016**

110

110

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

DAS

9

9-89

① 16-05-31

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
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Page 2

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N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

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Start Date: 5/13/2016 Start Qty: 1.00 *1*

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							DAS 9
120									
QC	Memo	0.00							9-89
Quality Control									
125	Pressure Wash per QSI005 4.3	0.00							
125									
HandFinish	Memo	0.33							
Hand Finishing									

1 16-05-31 13:34 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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April 13, 2016 3:45:03 PM

Page 3

Quality Control

10160531.DAS 34 9.89

1x 16/03/31 DAS 15 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Work Order ID 144369

April 13, 2016 3:45:03 PM

144369

Page 4

Item ID: D2221

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Base Assembly

Start Date: 5/13/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/20/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>W/O</u>	0.00							
150									
Packaging	Memo	0.01	D350-607-041	8144386		<u>12</u>	<u>7</u>	<u>18/05/30</u>	
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.10				<u>MCS</u>		JUN 01 2016	
Quality Control									

MCS JUN 01 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

April 13, 2016 3:45:03 PM

Page 1

Work Order ID: 144369

144369

Parent Item: D2221

D2221

Parent Item Name: Basket Base Assembly

Start Date: 5/13/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM
IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ *D2221-1* Rib		Manufactured	No			100	Each	6.0000	1	1		DAS 43 9-89	MAY 24 2016
				<u>Location</u>				<u>Loc Qty</u>			<u>Loc Code</u>		
				WA004				6					
				129923				6					
D2221-5		Manufactured	No			100	Each	6.0000	2	2		DAS 43 9-89	MAY 24 2016
✓ *D2221-5* Rib				<u>Location</u>				<u>Loc Qty</u>			<u>Loc Code</u>		
				WA004				6					
				127446				6					
D2221-7		Manufactured	No			100	Each	10.0000	1	1		DAS 43 9-89	MAY 24 2016
✓ *D2221-7* Rib				<u>Location</u>				<u>Loc Qty</u>			<u>Loc Code</u>		
				WA004				10					
				125057				4					
				98039				6					

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Picklist Print

April 13, 2016 3:45:03 PM

Page 2

Work Order ID: 144369

144369

Parent Item: D2221

D2221

Parent Item Name: Basket Base Assembly

Start Date: 5/13/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

D2232-3 Manufactured No

100 Each 32.0000 2 2

✓ ***D2232-3***

Basket Hinge

****B143693 → 2**

DAS

43

MAY 24 2016

9-89

Location

Loc Qty

Loc Code

WA004

32

141081

17

143693

15

D2235-1 Manufactured No

100 Each 5.0000 2 2

✓ ***D2235-1***

Basket Rib

****B127783 → 2**

DAS

43

MAY 24 2016

9-89

Location

Loc Qty

Loc Code

WA004

5

127783

5

D2581 Manufactured No

100 Each 84.0000 2 2

✓ ***D2581***

Mounting Bracket

****B142787 → 2**

DAS

43

MAY 24 2016

9-89

Location

Loc Qty

Loc Code

WA004

84

132771

1

136270

2

139082

13

141097

20

142787

48

D3442-1 Manufactured No

100 Each 25.0000 2 2

✓ ***D3442-1***

Shim

****B121484 → 2**

DAS

43

MAY 24 2016

9-89

Location

Loc Qty

Loc Code

WA004

25

121484

13

142837

12

April 13, 2016 3:45:03 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																															
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Picklist Print

April 13, 2016 3:45:03 PM

Page 3

Work Order ID: 144369

144369

Parent Item: D2221

D2221

Parent Item Name: Basket Base Assembly

Start Date: 5/13/2016

Required Date: 5/20/2016

Start Qty: 1.00

Required Qty: 1.00

D3825-041 Manufactured No

100 Each

8.0000

2 2

DAS

✓ *D3825-041*

Rib Assembly (Basket End)

**B130049 → 2

43

9-89

MAY 24 2016

Location

Loc Qty

Loc Code

WA004

8

119029

2

130049

6

D3826-041 Manufactured No

100 Each

4.0000

2 2

DAS

✓ *D3826-041*

Rib / Gusset Assembly

**B127436 → 2

43

9-89

MAY 24 2016

Location

Loc Qty

Loc Code

WA004

4

127436

4

D3827-041 Manufactured No

100 Each

3.0000

1 1

DAS

✓ *D3827-041*

Rib Assembly (Inboard)

**B127627 → 1

43

9-89

MAY 24 2016

Location

Loc Qty

Loc Code

WA004

3

127627

3

D3832-1 Manufactured No

100 Each

0.0000

1 1

✓ *D3832-1*

Mesh (Base)

**B147018 → 1

MAY 27 2016

D3833-1 Manufactured No

100 Each

10.0000

2 2

✓ *D3833-1*

Mesh (Base End Face)

**B114241 → 1

MAY 27 2016

Location

Loc Qty

Loc Code

WA004

1

132549

1

WA006

9

114241

9

April 13, 2016 3:45:03 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____

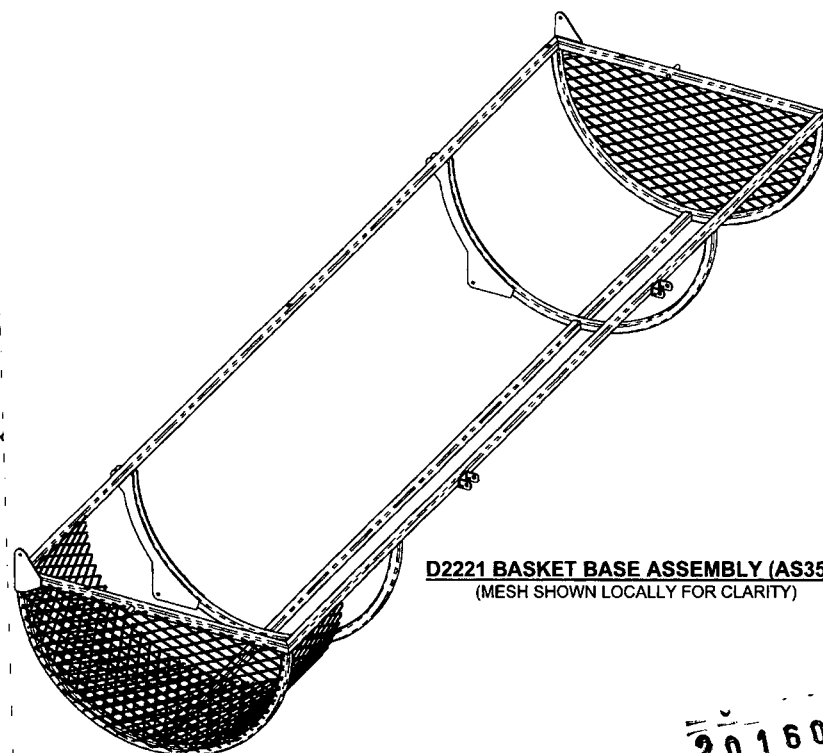


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

20160413
SH
144369

NOTES:

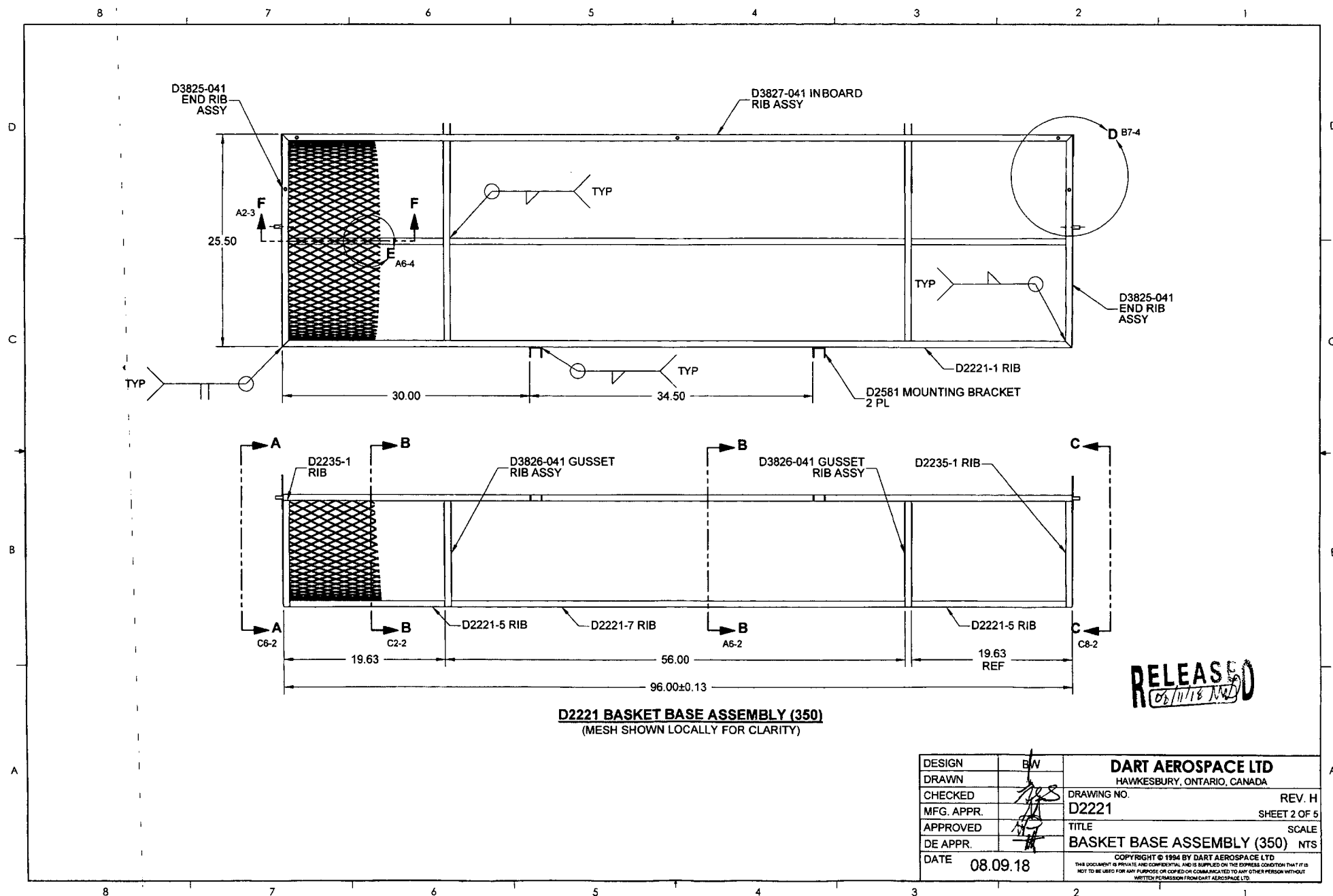
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING



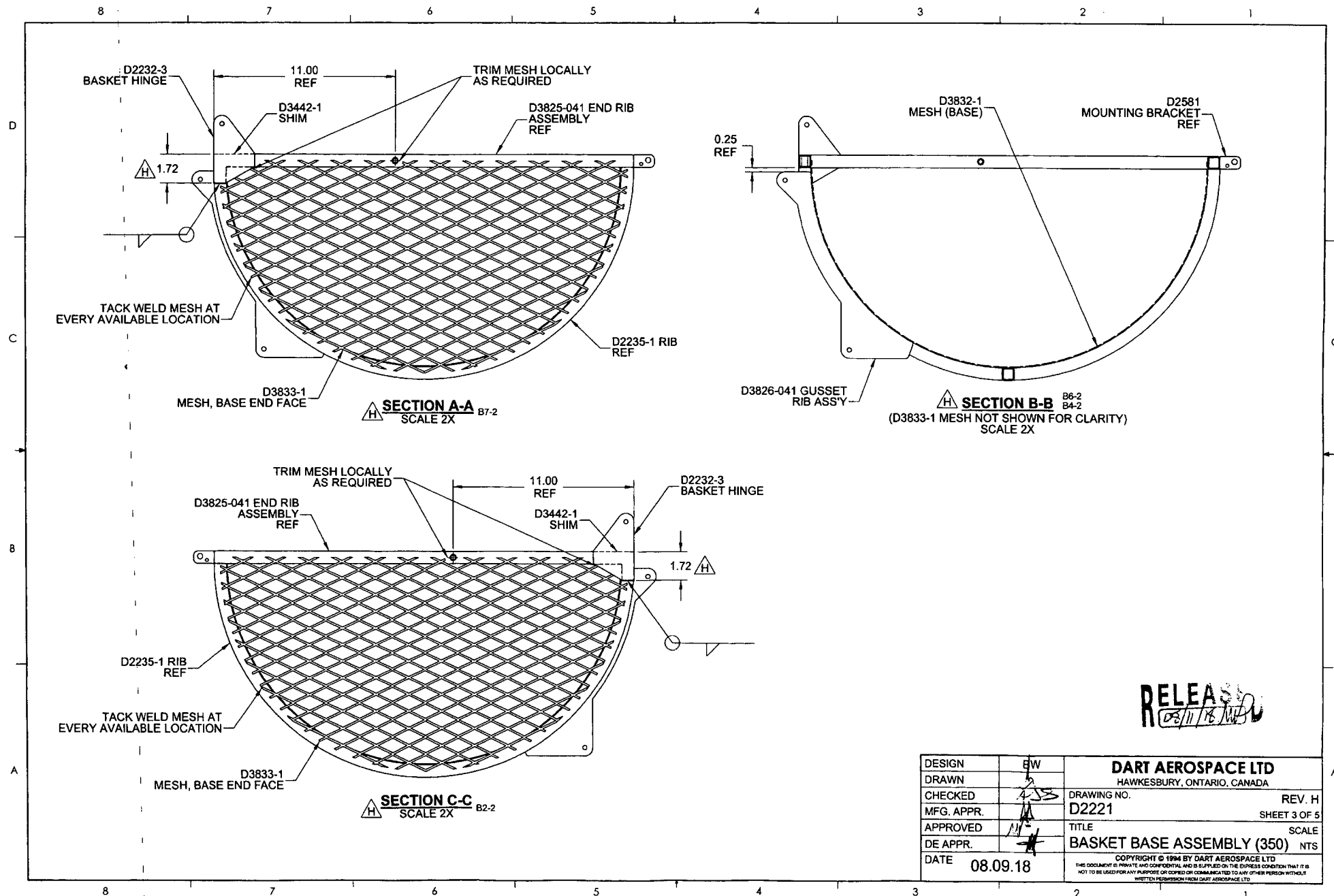
ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RELEASED
08/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1A-5/7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 98.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2, SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BS		
CHECKED	BS	DRAWING NO.	REV. H
MFG. APPR.	BS	D2221	SHEET 1 OF 5
APPROVED	BS	TITLE	SCALE
DE APPR.	BS	BASKET BASE ASSEMBLY (350)	NTS
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DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
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RELEASE
03/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.		TITLE	SHEET 3 OF 5
APPROVED		SCALE	
DE APPR.		BASKET BASE ASSEMBLY (350)	
DATE	08.09.18	NTS	

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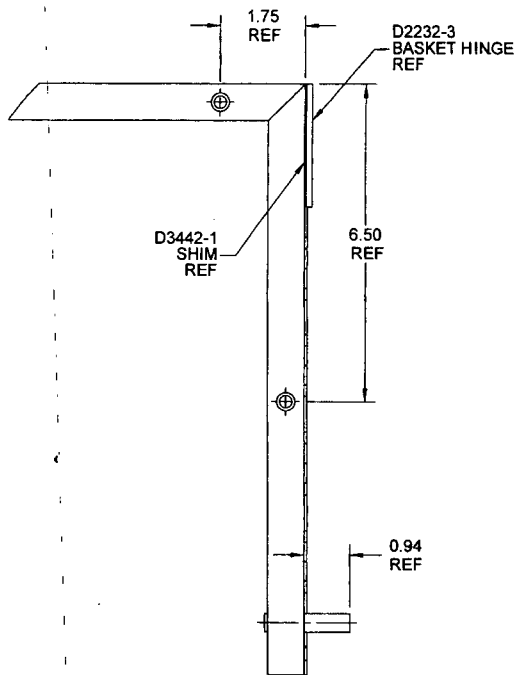
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D

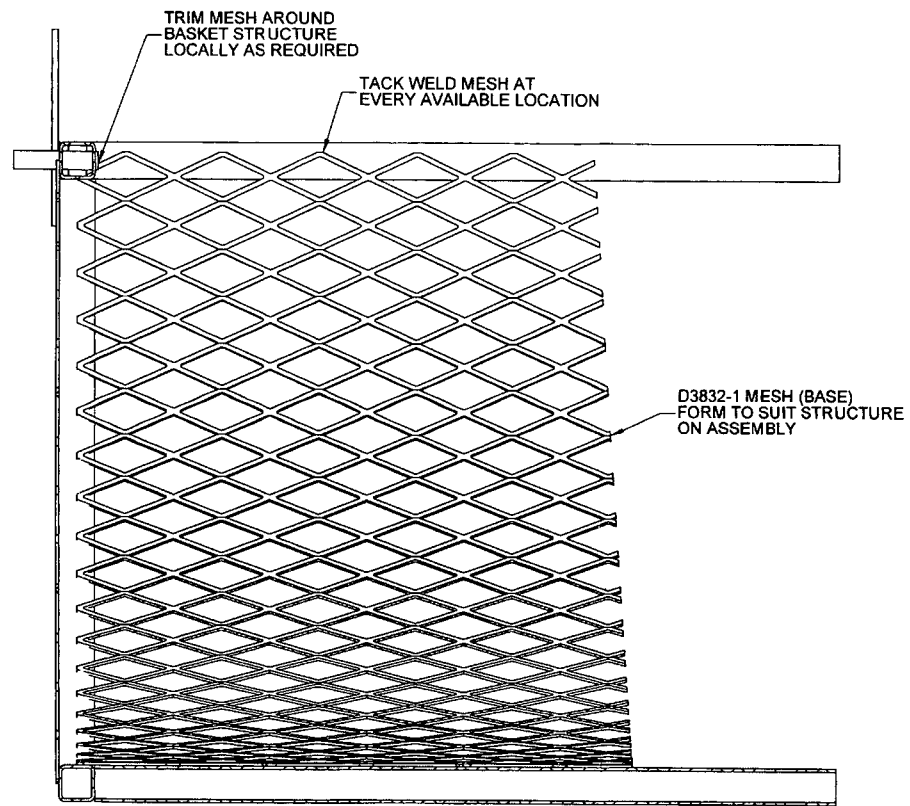
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B

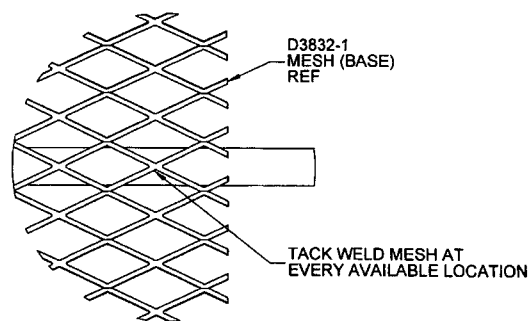
A



DETAIL D
SCALE 4X D2-2



SECTION F-F
SCALE 4X D7-2

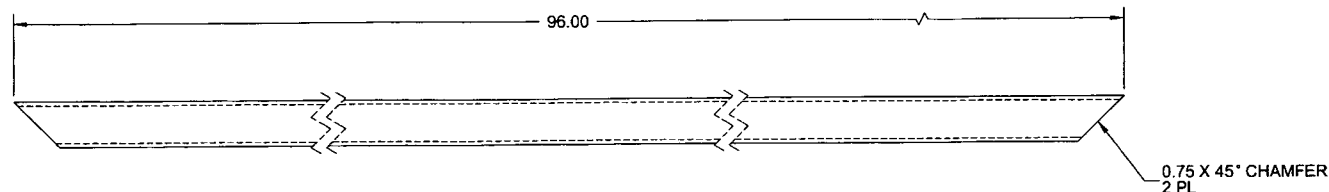
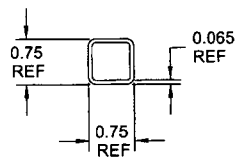


DETAIL E
SCALE 4X C6-2

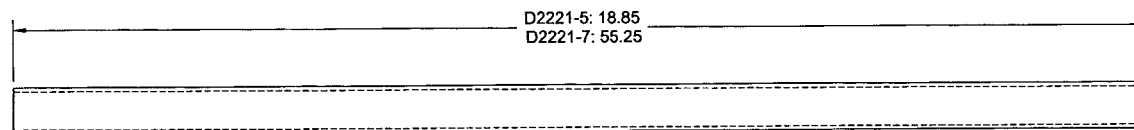
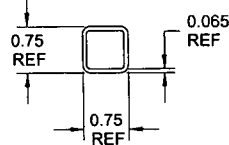
RELEASED
08/11/8 MJD

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D2221	REV. H
MFG. APPR.	<i>[Signature]</i>	SHEET 4 OF 5	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (350) NTS	
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8 7 6 5 4 3 2 1



D2221-1 RIB



D2221-5/-7 RIB

RELEASED
08/11/18

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2221-1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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